Qty:

16 Um:

16Pcs

160eSX

Each

: 205 SKIDTUBE "I" BEAM

: D2596

: N/A

: D

: D2596 REV D

: 19/11/2008

Wednesday, 12/11/2008 1:40:34 PM

User:

Julie Dawson

Process Sheet

Drawing Name

Part Number

Material **Due Date**

Drawing Number

Project Number

Drawing Revision

Customer Job Number : CU-DAR001 Dart Helicopters Services

S.O. No. :

: 43374 : 10346

Estimate Number

P.O. Number

: 12/11/2008 This Issue : NC Prsht Rev.

First Issue

: 11

: 43250

Previous Run

Written By

Checked & Approved By

Comment

Changed QA to QC, Added Step 6 and Cost

Type

Est Rev:E 07-07-09 Incorperated DEO 9183 JLM

: SKIDTUBES

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

Ext'n -'I' Beam Web 4"

1.0

D25003100

Comment: Qty.:

1.0000 Each(s)/Unit

Total;

16.0000 Each(s)

Extrusion "I" Beam Web 4"

Pick;

Qty

Part Number

D2500-3-100

Description

Extrusion

Batch 40/96 AWM 9-11-13
BESS RESOURCE 1

2.0

SKIDTUBES 1





- 1- Cut D2500-3-100 to length: 99.5"
- 2- Use Jig DT8093 to drill pilot holes #30
- 3- Open to 0.630" diameter as per Dwg D2596
- 4- Deburr

AUM 7-11-13

3.0

HAND FINISHING

Comment: HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1 AWM 8-11-13

4.0

QC5

INSPECT WORK TO CURRENT STEP

HAND FINISHING RESOURCE #1

Comment: INSPECT WORK TO CURRENT STEP





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W/O:		· ·	WO	RK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
No. de .									
Part No	:	PAR #:	Fault Categ	Jory:	_ NCR: Ye	s No D	QA:	Date: _	
	Re	solution:	Disposition):	_ QA: N/C	Closed: _		Date: _	
NCR:		1	WORK ORDE	R NON-CONFORMA	ANCE (NO	CR)			
D.A.T.E.	0750	Description of NC		Corrective Action Secti		Veri	fication	ation Approval App	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	1& _{Տա}	ction C	Chief Eng	QC Inspector
			1					1	

NOTE: Date & initial all entries

Date: User:

Wednesday, 12/11/2008 1:40:34 PM

Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 43374

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock Location:



6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Ae	rospace	Ltd							
W/O:			W	ORK ORDER CHANGES			λ,		
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cat	egory: Ne	CR: Yes	No DQ	A:	Date:	
Resolution:		Dispositi	Disposition: QA		QA: N/C Closed:		Date:		
NCR:			WORK OR	DER NON-CONFORMANC	E (NCI	R)			
				Corrective Action Section B	Veriticatio			Approval Appr	Approval
DATE STEP		Section A	Initial Chief Eng			0	tion C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

	DESIGN PAH	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
	CHECKED //	APPROVED 11.	DRAWING NO. REV. D
	*	*	D2596 SHEET 1 OF 1
•	DATE		THUS
	07.04.17		205 WEB 1:20
•	>	96.09.16	NEW ISSUE
	В	97.07.23	Ø0.63 HOLE WAS Ø0.56
	C	98.09.14	INCORPORATED DEO 9097
	D	07.04.17	07.04.17 INCORPORATED DEO 9183

	1.750 3	.500 1.750	
REFER TO	- 0.50 - 1.750 - 1.750	Ø0.63 (22 PLACES	6) - 0.50 (REF)
	8.75 — — 17.38 — — 26.00 — — 34.19	32.75 (REF) - 4 EQUAL SPACES -	REFER TO DETAIL A
SUBJECT TO AMENDMENT WITHOUT NOTICE WITHOUT NOTICE	42.38 46.01 50.56 85.59	8.19 PITCH	
KEZJEN TO KAJEERING ONTROLLED COP PECT TO AMENDMENT WITHOUT NOTICE VICTORY DESPITE		9.50 ————	

D2596 WEB

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- MATERIAL:
- MAKE FROM D2500-3-100 EXTRUSION CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 2) FINISH: ALL DIMENSIONS ARE IN INCHES 3)
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4)
- DEBURR SHARP EDGES 0.010 TO 0.020

DETAIL ASCALE 1:4